

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004428**Date Inspected:** 22-Oct-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Ken Zhang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Skin Plate**Summary of Items Observed:**

This report serves to document the events occurring on this date at the following location. Caltrans Quality Assurance (QA) Inspector Robert Vatcher arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Tower Assembly Bay II

QA arrived at south shaft skin "A" lift 2 to observe SMAW tack welding operations on 93 millimeter thick plate. QA observed the 110 Celsius preheat was not established for tack welding in the direct area where weld metal would be deposited. QA mentioned to the ZPMC QC personnel about the situation who mentioned that the tack welds would be completely re-melted upon Submerged Arc Welding operations. QA also noted that the layer thickness of the SMAW tack weld was greater than 6 mm. QA stated that the WPS utilized for this evolution required preheat of 110 Celsius. ZPMC personnel mentioned that they would continue to preheat to the required amount as stated in the welding procedure specification.

The above mentioned items, as observed and documented by QA, appear to be in conformance with the contract documents.

Summary of Conversations:

No relevant conversations this date.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco 138-1694-2685, who represents the Office of Structural Materials for your project.

Inspected By: Vatcher,Robert

Quality Assurance Inspector

Reviewed By: Cuellar,Robert

QA Reviewer